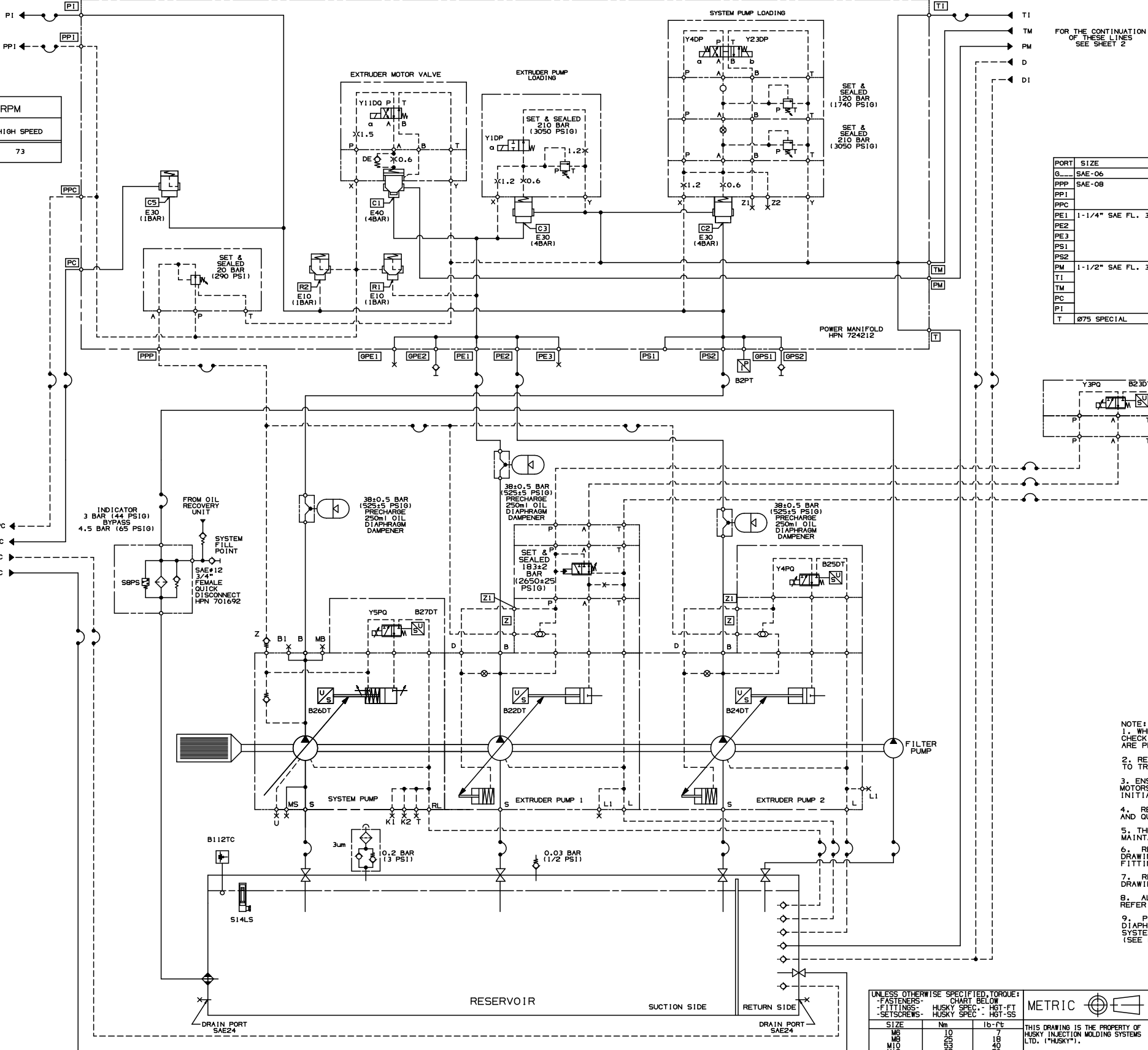


EXTRUDER RPM		
SCREW DIAMETER	STANDARD SPEED	HIGH SPEED
Ø 120mm	60	73

FOR THE CONTINUATION  
OF THESE LINES  
SEE SHEET 2



FOR THE CONTINUATION  
OF THESE LINES  
SEE SHEET 2

PORT	SIZE
G	SAE-06
PPP	SAE-08
PP1	
PPC	
PE1	1-1/4" SAE FL. 3000PSI
PE2	
PE3	
PS1	
PS2	
PM	1-1/2" SAE FL. 3000PSI
T1	
TM	
PC	
P1	
T	Ø75 SPECIAL

- NOTE:
1. WHEN REPLACING VALVES AND MANIFOLDS, BE SURE TO CHECK THAT THE CORRECT ORIFICES, AND/OR PLUGS ARE PRESENT AND RE-ASSEMBLE USING NEW O-RINGS.
  2. READ THE MAINTENANCE MANUAL BEFORE ATTEMPTING TO TROUBLESHOOT ANY HYDRAULIC PROBLEMS.
  3. ENSURE THAT THE CASES OF THE PUMPS AND THE HYDRAULIC MOTORS ARE FILLED WITH CLEAN HYDRAULIC FLUID BEFORE INITIAL STARTUP.
  4. REFER TO THE MAINTENANCE MANUAL FOR THE TYPE AND QUANTITY OF FLUID REQUIRED FOR THE SYSTEM.
  5. THE SYSTEM FLUID CLEANLINESS SHOULD BE MAINTAINED AT A LEVEL OF ISO4406 14/11 OR BETTER.
  6. REFER TO THE APPROPRIATE MECHANICAL INSTALLATION DRAWING TO OBTAIN PART NUMBERS OF PUMPS, HOSE, FITTINGS, ETC.
  7. REFER TO THE APPROPRIATE MANIFOLD ASSEMBLY DRAWING TO OBTAIN VALVE PART NUMBERS.
  8. ALL PRESSURE RELIEF VALVE SETTINGS INDICATED REFER TO CRACKING PRESSURE.
  9. PRECHARGE PRESSURE FOR ALL ACCUMULATORS AND DIAPHRAGM DAMPERS TO BE CHECKED AND ADJUSTED AFTER SYSTEM HAS REACHED STABLE OPERATING TEMPERATURE (SEE MACHINE MAINTENANCE MANUAL).

	DRWN:	
	CHKD:	
	DRWN:	
	CHKD:	
	DRWN:	
	CHKD:	
1	2001-03-06	DRWN: M.VERNEM CHKD: M.MILUNOVIC
0	2001-02-19	DRWN: M.VERNEM CHKD: M.MILUNOVIC
REV	DATE	NAME

UNLESS OTHERWISE SPECIFIED, TORQUE:		
FASTENERS	CHART BELOW	
FITTINGS	HUSKY SPEC.	HGT-FT
SETSCREWS	HUSKY SPEC.	HGT-SS
SIZE	Nm	lb-ft
M6	10	7
M8	25	18
M10	50	40
M12	65	70
M14	130	95
M16	220	160
M18	270	200
M20	390	290
M24	650	490
M30	1300	980
M36	2300	1700
M42	3700	2700
M48	5500	4000

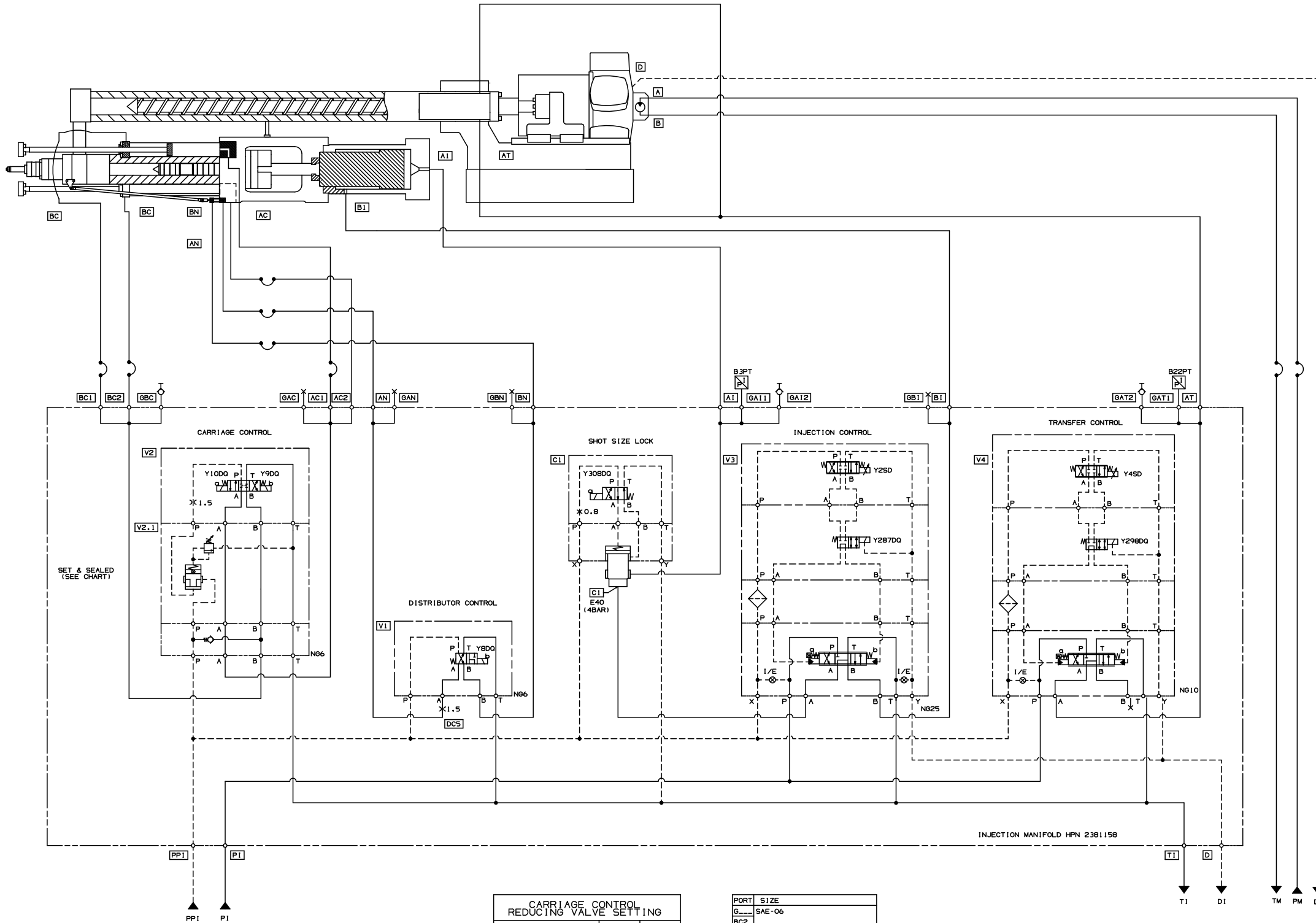
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POWER			
HUSKY INJECTION MOLDING SYSTEMS LTD.			
TITLE HYDRAULIC SCHEMATIC5 GL 300 PET P100/110 E120 STANDARD SPEED 50 Hz HIGH SPEED 60 Hz			
SCALE	N/A	SIZE	DRAWING
SHEET 1 OF 4	A2	2376934	REV 1

WEIGHT N/A kg

A

B



FOR THE CONTINUATION  
OF THESE LINES  
SEE SHEET 1

CARRIAGE CONTROL REDUCING VALVE SETTING		
MELT CHANNEL DIAMETER	BAR	PSI
32 mm	124±2	1800±25

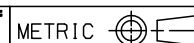
PORT	SIZE
G	SAE-06
BC2	
BC1	
AC1	
AC2	
AN	
BN	
D	SAE-08
PP1	
B1	Ø37 SPECIAL
T1	1-1/2" SAE CODE 61 FLANGE
AT	SAE-16
A1	Ø55 SPECIAL

WEIGHT N/A kg

UNLESS OTHERWISE SPECIFIED, TORQUE: -FASTENERS- CHART BELOW -FITTINGS- HUSKY SPEC - HGT-FT -SETSCREWS- HUSKY SPEC - HGT-SS		
SIZE	Nm	lb-ft
M6	10	7
M8	25	18
M10	53	40
M12	68	50
M14	130	95
M16	220	160
M18	270	200
M20	390	290
M24	850	630
M30	1300	960
M36	2300	1700
M42	3700	2700
M48	5500	4000

APPLY PROPER LUBRICANT TO ALL THREADS &  
CONTACTING SURFACES BEFORE INSTALLATION.

FOR THE CONTINUATION  
OF THESE LINES  
SEE SHEET 1



INJECTION				
HUSKY INJECTION MOLDING SYSTEMS LTD.				
TITLE HYDRAULIC SCHEMATIC5 GL 300 PET P100/110 E120 STANDARD SPEED 50 Hz HIGH SPEED 60 Hz				
SCALE	N/A	SIZE	DRAWING	REV
SHEET 2 OF 4	A2	2376934	1	

DRAWING  
2376934  
REV  
1

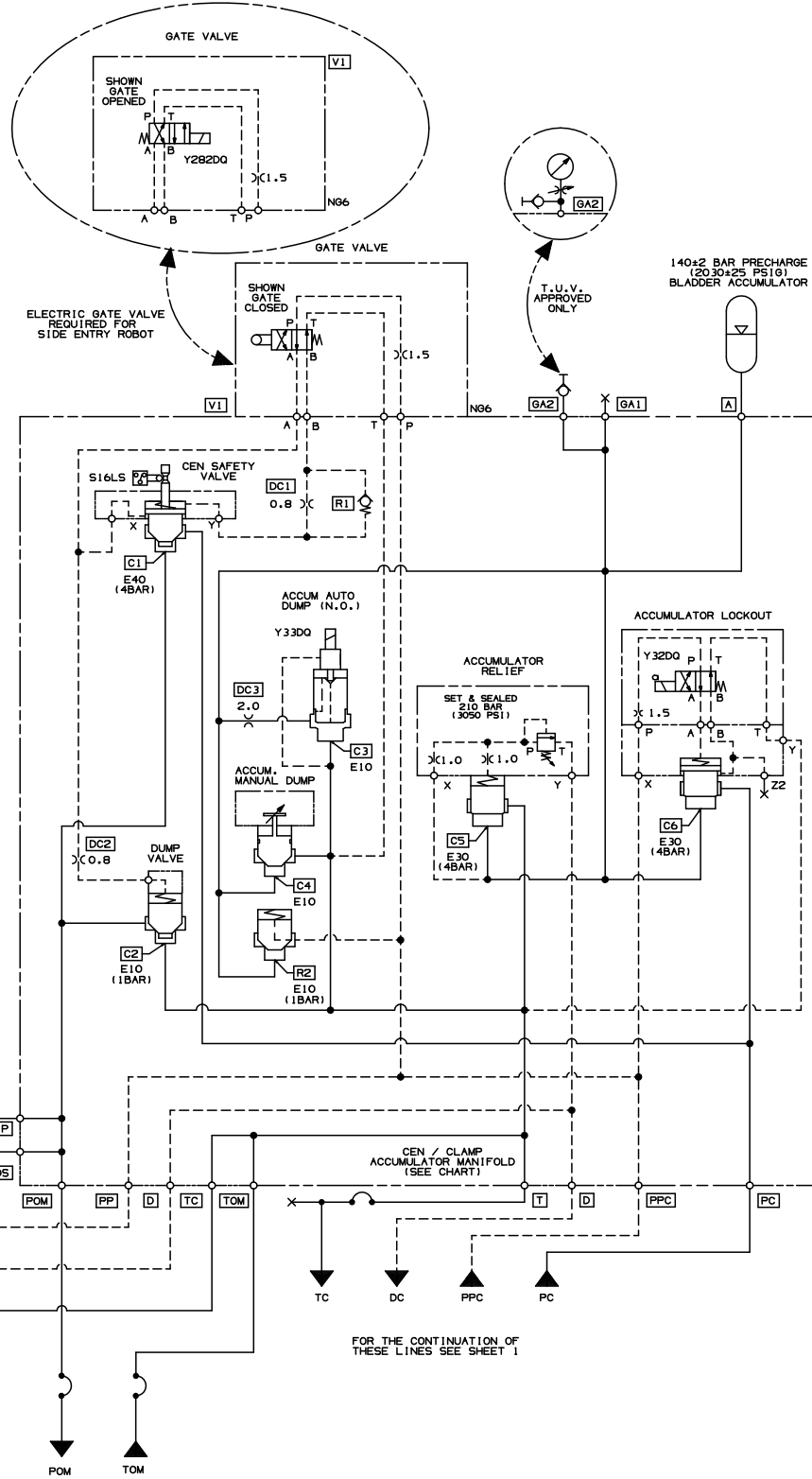
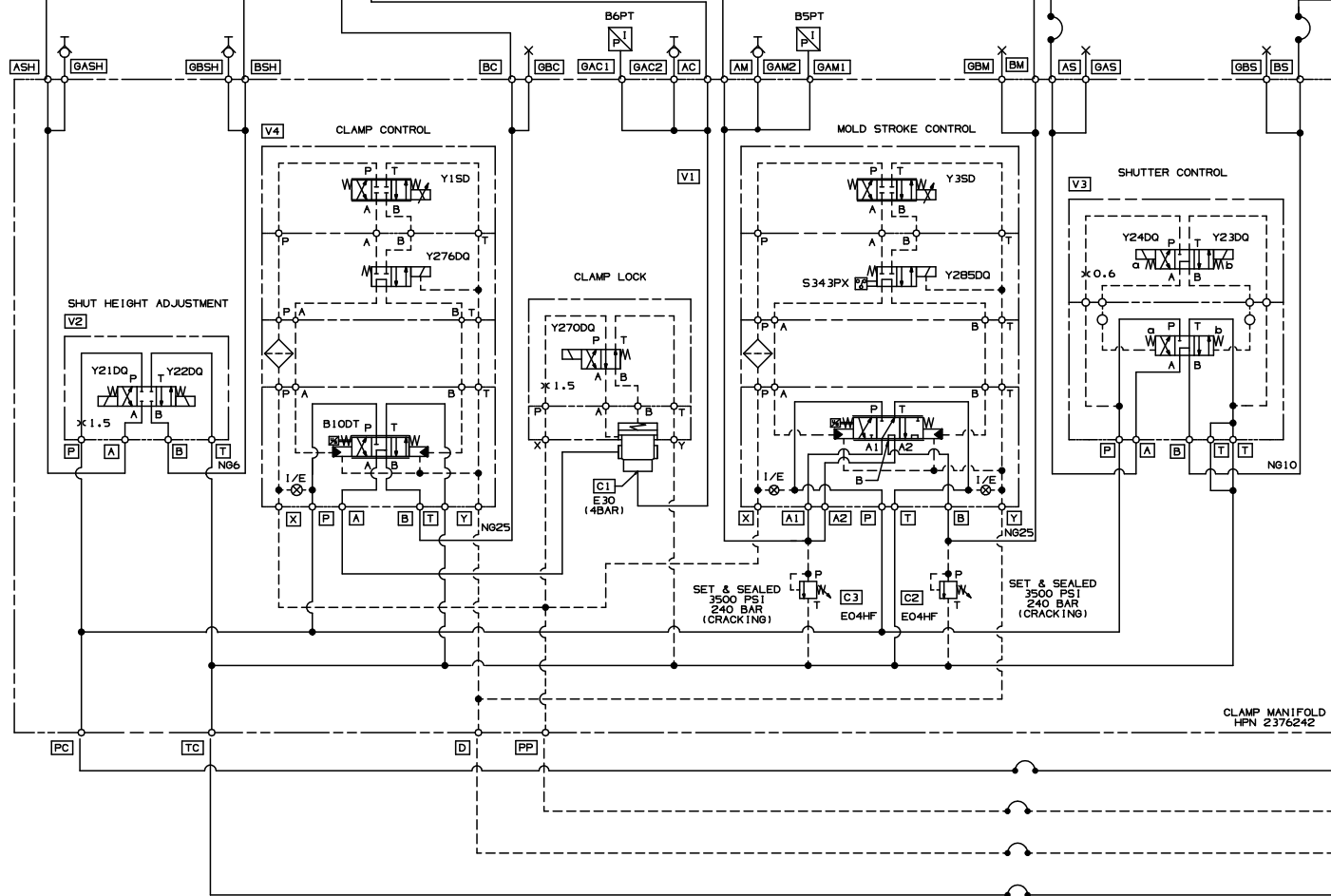
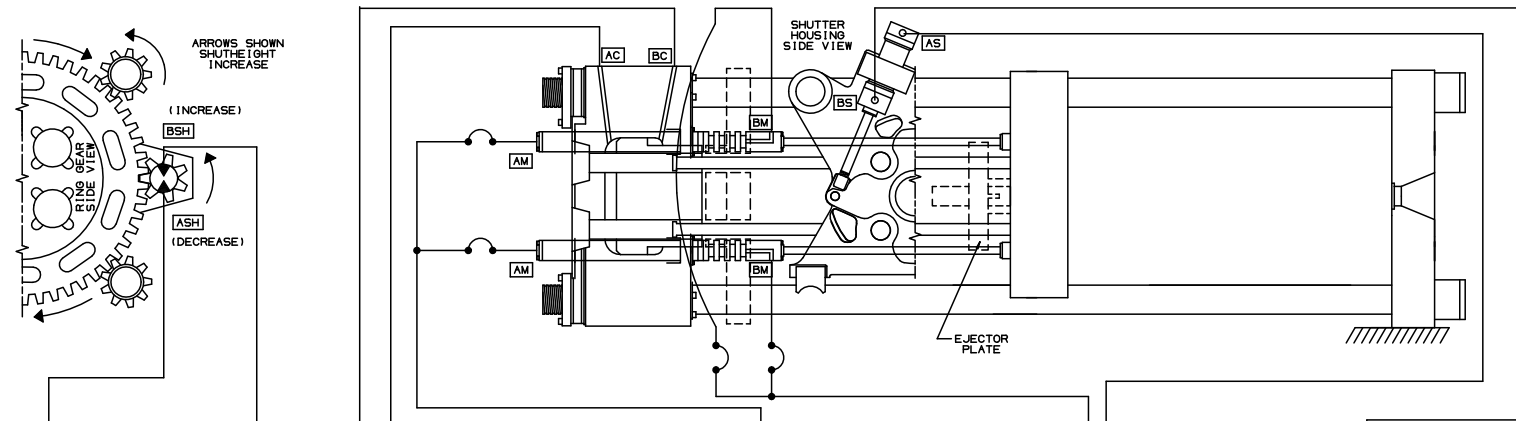
A

B

1

1

2



CLAMP FULL TONNAGE PRESSURE		
CLAMP TONNAGE	OIL PRESSURE	
	BAR	PSI
300	166	2400

CLAMP ACCUMULATOR SIZE	
CLAMP TONNAGE	ACCUMULATOR SIZE (LITRES)
300	1 X 34.1

PORT	SIZE
G	SAE-06
D	SAE-08
PP	
PPC	
ASH	
BSH	
AS	SAE-12
BS	
POS	SAE-16
POM	
TOM	
AM	SAE-20
BM	
PC	(CEN) SAE-24 (CLAMP) 1-1/2" SAE CODE 61
TC	2" SAE CODE 61 FLANGE
A	
T	2-1/2" SAE CODE 61 FLANGE
P	1-1/2" SAE CODE 61 FLANGE
BC	Ø16
AC	Ø30

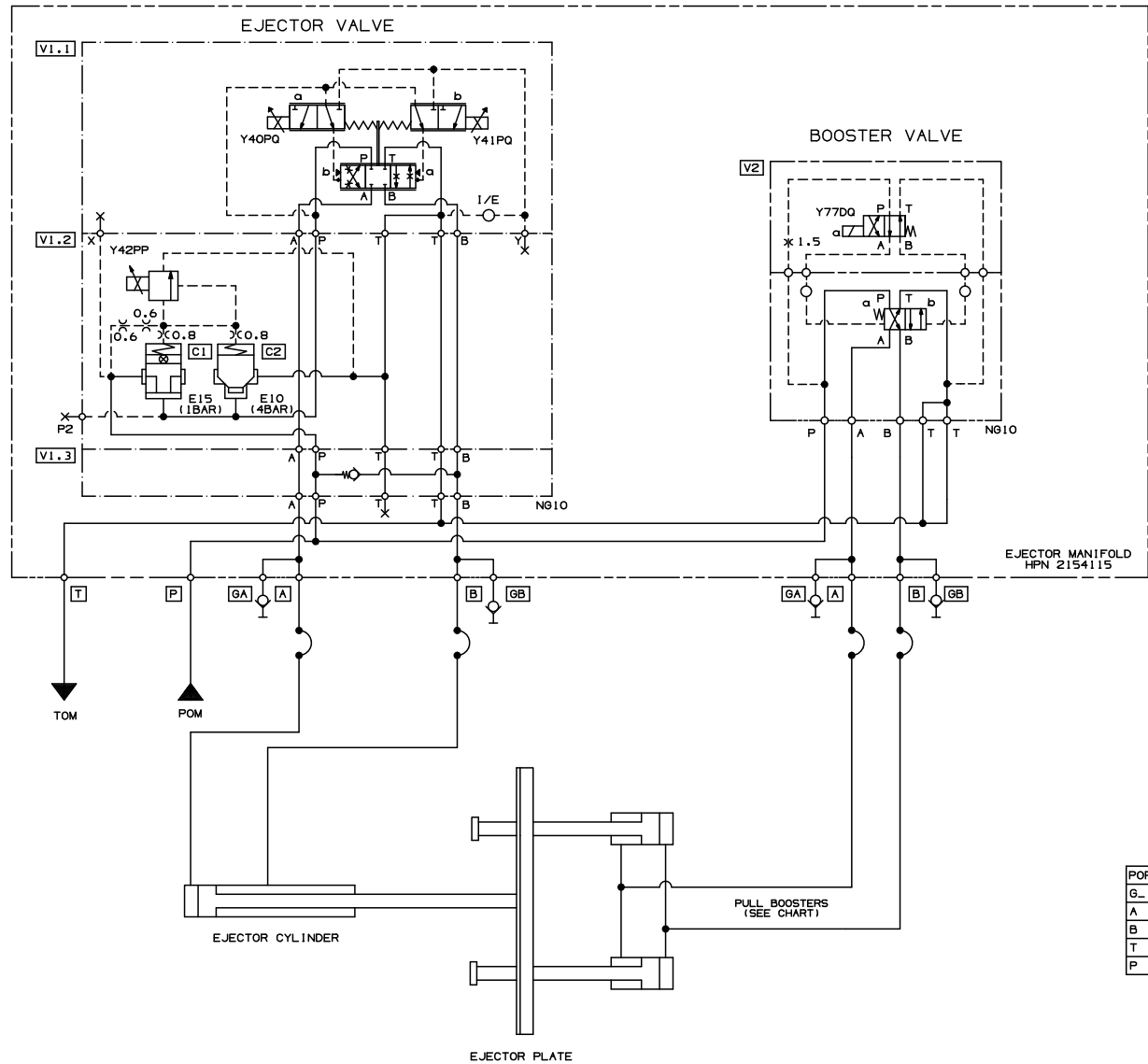
CEN/CLAMP ACCUMULATOR MANIFOLD		
	MECHANICAL GATE VALVE	ELECTRIC GATE VALVE
STANDARD	721908	726772
TUV	721909	731171

	DRWN:	
	CHKD:	
	DRWN:	
	CHKD:	
	DRWN:	
	CHKD:	
1	2001-03-06	DRWN: M.VERNEM CHKD: M.MILUNOVIC
0	2001-02-19	DRWN: M.VERNEM CHKD: M.MILUNOVIC
REV	DATE	NAME

WEIGHT	
N/A kg	
TORQUE TO HUSKY SPECIFICATION	
UNLESS OTHERWISE SPECIFIED	FASTENERS: HBT-50 FITTINGS: HBT-FT SET SCREWS: HBT-SS

METRIC	
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CLAMP			
HUSKY INJECTION MOLDING SYSTEMS LTD.			
TITLE			
HYDRAULIC SCHEMATIC5 GL 300 PET P100/110 E120 STANDARD SPEED 50 Hz HIGH SPEED 60 Hz			
SCALE	N/A	SIZE	DRAWING
SHEET 3 OF 4	A2	2376934	REV 1



PORT	SIZE
G <sub>L</sub>	SAE-06
A	SAE-12
B	
T	SAE-16
P	

MECHANICAL VALVE SETTINGS	
PROPORTIONAL PRESSURE CONTROL VALVES	1-1/2 TURNS COUNTER CLOCKWISE OUT FROM FULLY SEATED

CLAMP TONNAGE	PULL BOOSTER QUANTITY
300	FOUR (4)

		DRWN:
		CHKD:
		DRWN:
		CHKD:
		DRWN:
		CHKD:
1	2001-03-06	DRWN: M.VERNEM
		CHKD: M.MILUNOVIC
0	2001-02-19	DRWN: M.VERNEM
		CHKD: M.MILUNOVIC
REV	DATE	NAME

WEIGHT	N/A kg
TORQUE TO HUSKY SPECIFICATION	
UNLESS OTHERWISE SPECIFIED	FASTENERS: HBT-50 FITTINGS: HBT-FT SET SCREWS: HBT-SS

METRIC		INJECTION MOLDING SYSTEMS LTD.
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TITLE HYDRAULIC SCHEMATIC5 GL 300 PET P100/110 E120 STANDARD SPEED 50 Hz HIGH SPEED 60 Hz		
SCALE	N/A	SIZE
SHEET 4 OF 4	A2	2376934
DRAWING	REV	1